

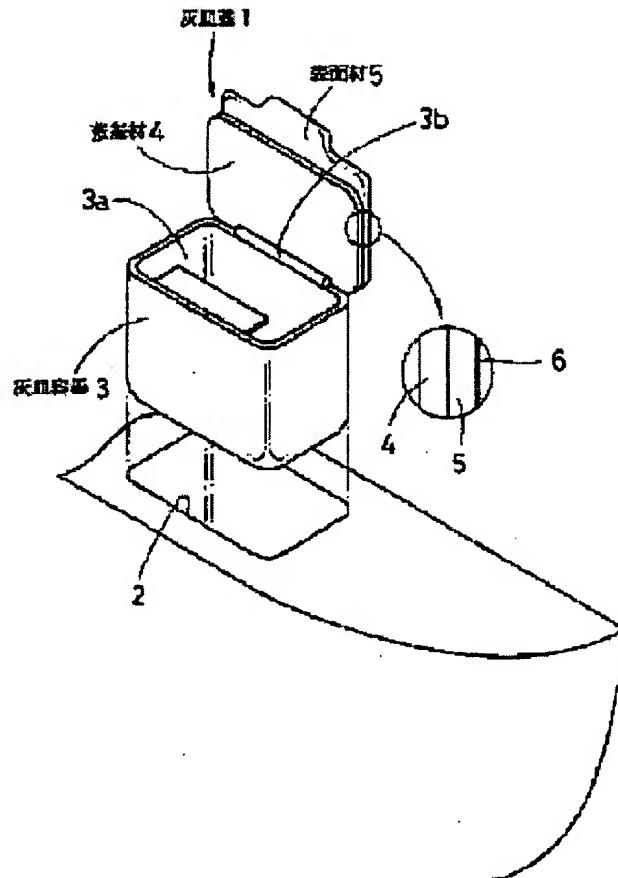
## ASH TRAY COVER AND ASH TRAY

**Patent number:** JP11268574  
**Publication date:** 1999-10-05  
**Inventor:** YAMADA TOMOHIRO; TAKENAKA TOMONARI; ASAI HIROMITSU  
**Applicant:** TRINITY IND CORP  
**Classification:**  
- **international:** B60N3/08; A24F19/00; B29C45/16; B29K55/02;  
B29K81/00; B29L22/00  
- **european:**  
**Application number:** JP19980074168 19980323  
**Priority number(s):** JP19980074168 19980323

[Report a data error here](#)

### Abstract of JP11268574

**PROBLEM TO BE SOLVED:** To mold an ash tray and an ash tray cover by using poly phenylene sulfide(PPS) recently increasing a production amount and lowering its price to perform surface decoration being secondary processing without applying primer processing after molding thereof. **SOLUTION:** The cover base material 4 of an ash tray cover 1 is molded by using PPS having excellent flame retardance, and molding is effected such that the surface thereof is covered with a surface material 5 of ABS resin having excellent painting properties and printing properties, whereby a pattern and a design for decoration are directly printed or painted without applying primer treatment. In this case, since, after the surface material 5 is molded by using ABS resin, molding is effected by two-time injection molding that the cover base material 4 is molded by using PPS, the two materials are firmly thermally welded. Further, since molding shrinkage of a cover base material 4 occurring thereafter and a shrinkage factor occasioned by cooling of the surface material 5 pressurized by the mold are low, the surface material 5 is prevented from peeling from the surface of the cover base material 4 and the occurrence of a defective product is decreased.



Data supplied from the **esp@cenet** database - Worldwide



- PN - JP11268574 A 19991005  
 PD - 1999-10-05  
 PR - JP19980074168 19980323  
 OPD - 1998-03-23  
 TI - **ASHTRAY COVER AND ASHTRAY**  
 AB - PROBLEM TO BE SOLVED: To mold an ash tray and an ash tray cover by using poly phenylene sulfide(PPS) recently increasing a production amount and lowering its price to perform surface decoration being secondary processing without applying primer processing after molding thereof.  
 SOLUTION: The **cover** base material 4 of an **ash tray cover** 1 is **molded** by using PPS having excellent flame retardance, and **molding** is effected such that the surface thereof is **covered** with a surface material 5 of ABS resin having excellent painting properties and printing properties, whereby a pattern and a design for decoration are directly printed or painted without applying primer treatment. In this case, since, after the surface material 5 is **molded** by using ABS resin, **molding** is effected by two-time injection **molding** that the **cover** base material 4 is **molded** by using PPS, the two materials are firmly thermally welded. Further, since **molding** shrinkage of a **cover** base material 4 occurring thereafter and a shrinkage factor occasioned by cooling of the surface material 5 pressurized by the **mold** are low, the surface material 5 is prevented from peeling from the surface of the **cover** base material 4 and the occurrence of a defective product is decreased.
- IN - YAMADA TOMOHIRO; TAKENAKA TOMONARI; ASAHI HIROMITSU  
 PA - TRINITY IND CORP  
 IC - B60N3/08; A24F19/00; B29C45/16; B29K55/02; B29K81/00; B29L22/00  
 © WPI / DERWENT
- TI - Ashtray **lid** structure in cars, electric trains, aircraft - includes **lid** base and heat welded decorative portion **molded** separately using different resins  
 PR - JP19980074168 19980323  
 PN - JP11268574 A 19991005 DW199953 B60N3/08 006pp  
 PA - (TRIN-N) TRINITY IND CORP  
 IC - A24F19/00 ;B29C45/16 ;B29K55/02 ;B29K81/00 ;B29L22/00 ;B60N3/08  
 AB - JP11268574 NOVELTY - An ashtray **lid** (1) includes **lid** base (4) **molded** by polyphenylene sulfide (PPS) and decorative surface layer (5) separately **molded** by acrylonitrile butadiene styrene (ABS) resin. Heat welding of the base and decorative layer is performed. DETAILED DESCRIPTION - An INDEPENDENT CLAIM is also included for an ashtray which has a decorative surface portion **molded** by ABS resin and a tray receptacle separately **molded** by PPS resin.  
 - USE - For disposal of cigarette ends in cars, electric trains and aircraft.  
 - ADVANTAGE - PPS resin is excellent in heat resistance and ABS resin is excellent in coating or printing property, hence surface decoration is performed without priming after completion of **molding**. Decorative surface portion is first **molded** by ABS resin, then a **lid** base is **molded** by PPS; hence thermal expansion is restrained within the **mold** and amount of contraction by cooling is small. Compared to ABS resin, the co-efficient of linear expansion of PPS is small. Therefore a decorative surface layer does not peel from base. DESCRIPTION OF DRAWING - The figure shows the ashtray **lid** structure. (1) Ashtray **lid**; (4) **lid** base; (5) Decorative surface layer.  
 - (Dwg.1/5)  
 OPD - 1998-03-23  
 AN - 1999-615141 [53]  
 PN - JP11268574 A 19991005

- PD - 1999-10-05  
AP - JP19980074168 19980323  
IN - YAMADA TOMOHIRO;TAKENAKA TOMONARI;ASAI HIROMITSU  
PA - TRINITY IND CORP  
TI - ASHTRAY COVER AND ASHTRAY  
AB - PROBLEM TO BE SOLVED: To mold an ashtray and an ashtray cover by using poly phenylene sulfide(PPS) recently increasing a production amount and lowering its price to perform surface decoration being secondary processing without applying primer processing after molding thereof.  
- SOLUTION: The cover base material 4 of an ashtray cover 1 is molded by using PPS having excellent flame retardance, and molding is effected such that the surface thereof is covered with a surface material 5 of ABS resin having excellent painting properties and printing properties, whereby a pattern and a design for decoration are directly printed or painted without applying primer treatment. In this case, since, after the surface material 5 is molded by using ABS resin, molding is effected by two-time injection molding that the cover base material 4 is molded by using PPS, the two materials are firmly thermally welded. Further, since molding shrinkage of a cover base material 4 occurring thereafter and a shrinkage factor occasioned by cooling of the surface material 5 pressurized by the mold are low, the surface material 5 is prevented from peeling from the surface of the cover base material 4 and the occurrence of a defective product is decreased.  
SI - B29K55/02 ;B29K81/00 ;B29L22/00  
I - B60N3/08 ;A24F19/00 ;B29C45/16

く、また、PPSはABS樹脂に比して線膨張係数が小さいので、双方の収縮量の差はほとんどなく、したがって、表面材が蓋基材の表面から剥離することもなく、製品不良が少ないという効果もある。

### 【図面の簡単な説明】

【図1】 本発明に係る灰皿蓋を示す図

【図2】(a)～(d)はその成形工程図。

【図3】 本発明に係る灰皿を示す図。

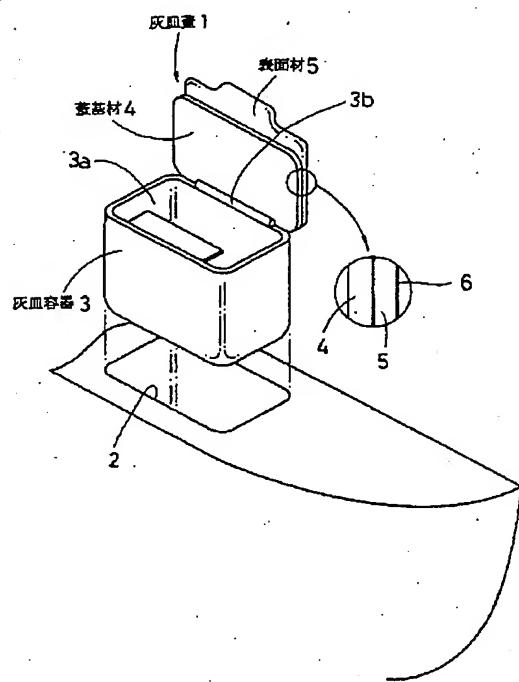
【図4】 その成形装置を示す説明図。

〔図5〕 本発明に係る他の灰皿を示す図。

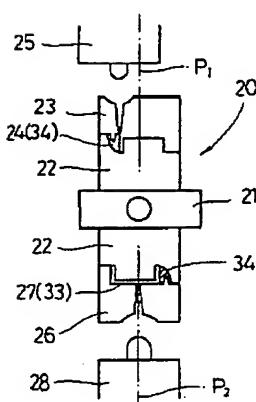
### 【符号の説明】

- 1 . . . 灰皿蓋  
 3 . . . 灰皿容器  
 4 . . . 蓋基材  
 5, 34, 44 . . . 表面材  
 30, 40 . . . 灰皿  
 33 . . . トレー形容器  
 43 . . . ポケット形容器

[圖1]



( 4)



【图2】

